

Work Order ID 70472-2

Thursday, June 09, 2011 8:29:53 AM



Page 1

Item ID: D3609-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/9/2011

Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2011

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3609

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3609

Dwg Rev: E

Prog Rev:

2-Deburr if necessary

B11-6-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-10

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/6/10

(H6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70472

Thursday, June 09, 2011 8:29:53 AM



Page 2

Item ID: D3609-1

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Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

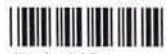
Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

121



Brake NC

Form as per dwg

0.00

Memo

0.00

Brake NC

USE DT9760 TOOL

SB 1160410

122



Small Fab

Memo

0.00

Small Fab

1- TRIM AS PER DWG USING GUIDE LINES

SB 11606113

123



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

S 11606113

(14)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70472

Thursday, June 09, 2011 8:29:53 AM



Page 3

Item ID: D3609-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

PPP70471

0.00

Packaging

14/6/13

(4)

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

USE DT9760 TOOL

0.00

Quality Control

11/6/13

CL1106113

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 09, 2011 8:30:00 AM

Page 1

Work Order ID: 70472

Parent Item: D3609-1

Parent Item Name: Doubler



Start Date: 6/9/2011

Required Date: 6/10/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
 IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC IPP REV:C
 AS PER REV C JLM 11-05-04 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S22GA

Purchased

No

100

sf

71.2600

1.1769

7.433053



304/316 .032 Sheet



IB 11-6-10

Location

Loc Qty

Loc Code

020

7

109057

7

MAT020

64.26

117379

64.26

117379

6

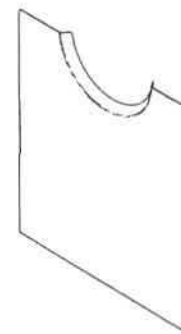
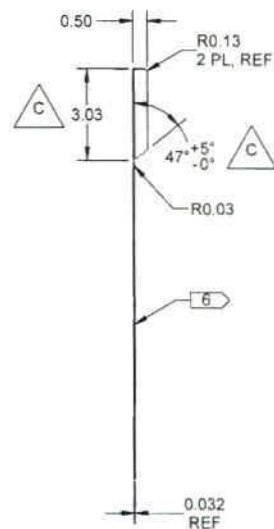
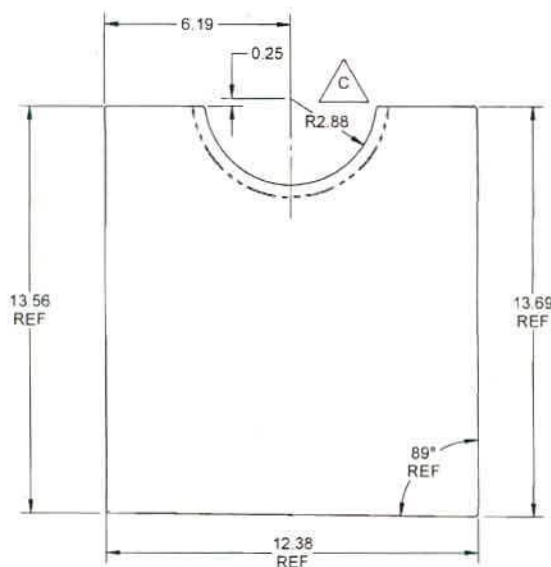
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3609-1 DOUBLER

NOTES:

- 1) MATERIAL: MAKE FROM D3609-1F FLAT PATTERN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.46 lbs
- 8) FORM USING DT9763 AND TRIM PER PHANTOM LINE ON SHEET 2

W/6 70172

RELEASED
2011-06-09

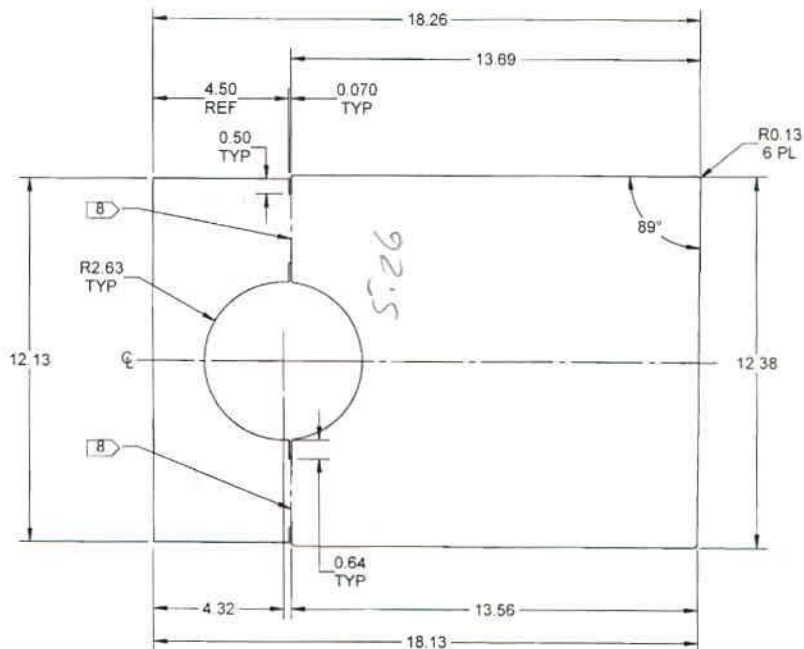
C	2.88 WAS 2.98 (ZN C5-1); 3.03 WAS 3.20 (ZN C4-1); ADD ANGLE TOLERANCE (ZNC3-1); REVISE D3609-1F	RF	11.06.07
B	ADD BEVEL (ZN C3-1); ADD FLAT PATTERN (ZN B4-2)	RF	11.04.28
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	REF		
DRAWN	REF		
CHECKED	REF		
MFG. APPR.	REF		
APPROVED	REF		
DE APPR.	REF		
DATE	11.06.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3609** REV. C
SHEET 1 OF 2

TITLE **DOUBLER** SCALE NTS

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D3609-1F FLAT PATTERN

RELEASED
2011-06-09

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM 240
OR ASME SA240
PER DART SPEC M304S22GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.87 lbs

DESIGN	REF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. C
MFG. APPR.		D3609	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	11.06.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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